Friday, 7/21/2006 7:37:02 AM User: Kim Johnston **Process Sheet Drawing Name** : SADDLE SPACER : CU-DAR001 Dart Helicopters Services Customer **Job Number** : 28016 : 10764 **Estimate Number** : D2876 : NB **Part Number** P.O. Number : D2876 REV B S.O. No. : NA **Drawing Number** : 7/21/2006 This Issue Project Number : N/A Prsht Rev. : NA : MACHINED PARTS **Drawing Revision** First Issue Type NOTE:1 BLANK MAKES 4 PARTS : 26367 Material **Previous Run Due Date** : 8/20/2006 Qty: 120 Um: Each Written By Checked & Approved By Added inspect level 8 EC : Esr Rev:B 00 Comment Est Rev:C Now M6061-T6 06-06-23 JLM **Additional Product** Job Number: Description: Seq. #: 6061-T6 .100 Sheet 1.0 M6061T6S100 Comment: Qty.: 0.0542 sf(s)/Unit Total: 6.5016 sf(s) Material: 6061-T6 (QQ-A-250/8) 0.100" Thick FLOW WATER JET 2.0 120 Comment: FLOW WATER QC2 3.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 120 D6:08:02 3A9 4.0 QC8 SECOND CHECK Comment: SECOND CHECK SMALL FAB SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 FF 06.08.15 W Tumble HAND FINISHING RESOURCE #1 . 6.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1

Page 1

W/O:		WORK ORDER CHANGES		•			
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
66 08·63	5	Add the few water Set tabs on the parts to be removed,	G	d. 09.03)	Ossun	(6080)

NCR:		W	ORK OR	DER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	
DATE	STEP	Section A		Initial Action Description Sign &		Section C	Approval Design Mgr	Approval QC Inspector
06-08-03	2.0	y parts scrop. Deep marks, blown out from the water Jet, At hole locations.	Bushis	destroy. No replace.	M.F. OYOU! O3.	06 08 03	RESTUR	060003

Part No:	PAR #:	Fault Category:	NCR:	Yes No Do	QA:	Date: 06.08.27
NOTE: Date & initial all entries				QA: N/C Clos	ed:	Date:

Date:

Friday, 7/21/2006 7:37:03 AM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 28016

Part Number: D2876

Job Number:



Seq. #:

Machine Or Operation:

Description:

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION





8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \$7393

9.0

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Dart A	erospac	e Ltd							
W/O:			WO	RK ORDER CHANGES					
DATE STEP		PRO	OCEDURE CHAN	NGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
.,									
NCR:	,		WORK ORDE	ER NON-CONFORMANC	E (NCI	₹)			
	T	Description of NC		Corrective Action Section B	-	Vorifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign of Date	Sect	ion C	Design Mgr	QC Inspector
		•							

NOIX.					, ,			
		Description of NC		Corrective Action Section B		Verification	Annroval	Annroval
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC inspector
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Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA:	Date:
NOTE: Date & initial all entries				QA: N	1/C C	losed:	Date:

DART AEROSPACE LTD	Work Order:	28016
Description: Saddle Spacer	Part Number:	D2876
Inspection Dwg: D2876 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First	t Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.98	+/-0.030	0.99	/		Vern	
1.00	+/-0.030	0,99	/		Vern	
Ø0.257	+0.005/-0.000	00.258			Vern	
3.35	+/-0.030	3,34	i/		Vertical Vern	
2.48	+/-0.030	2.48	V		Vern	
0.555	+/-0.010	2.48	V		Vertical	

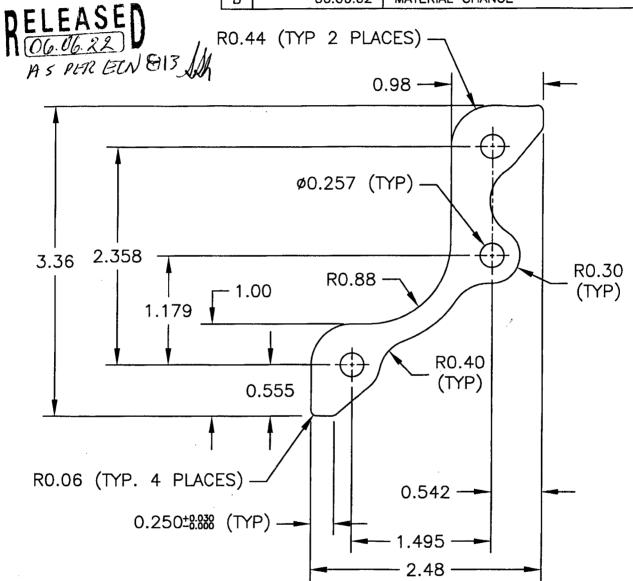
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Measured by:	Audited by:	Prototype Approval:	N/A
Date: 66:68!02	Date: Oi ve. u3	Date:	N/A

Date	Change	Revised by	Approved
03.12.15	New Issue	KJ/RF	
04.06.15	Removed 0.250 dimension	KJ/JLM ,	1
06.06.23	Dwg Rev. changed	KJ/JLM of	
	03.12.15 04.06.15	03.12.15 New Issue 04.06.15 Removed 0.250 dimension	03.12.15 New Issue KJ/RF 04.06.15 Removed 0.250 dimension KJ/JLM



DESIG	" of	DRAWN BY	DART AEROSPA HAWKESBURY, ONTARIO,	
CHECK		APPROVED	DRAWING NO.	REV. B
	PH		D2876	SHEET 1 OF 1
DATE			TITLE	SCALE
06.0	6.02		SADDLE SPACER	1:1
Α		99.02.23	NEW ISSUE	77
В	-	06.06.02	MATERIAL CHANGE	



NOTES:

1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.100" THICK (REF DART SPEC M6061T6S.100)

3HOP COPY RETURN TO ENGINEERING

5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.100" THICK CONTROLLED COPY (REF DART SPEC M5052H32S.100)

SUBJECT TO AMENDMENT

2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WITHOUT NOTICE

BREAK ALL SHARP EDGES 0.010 TO 0.020

ALL DIMENSIONS ARE IN INCHES

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